



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4893-1
Job Sheet 167967



Part No: D4893-1

Job Qty: 4 Ea

Part Name: Hard Point Adapter, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Pacific Helicopters Pty - Asia Pacific (CPACI02)

PO Box 342, Goroka, Eph Papua, , 441 Papua New Guinea ph:011 675 732 1833 fx:011 (675) 5321503.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		mml 17/11/29
100	Bandsaw	4 pcs	11/23/17	11/23/17	0.00	0.00	Bandsaw1		mml 17/11/29
110	CNC Vertical Machining	4 pcs	11/23/17	11/23/17	0.24	5.33	HAAS 1		mml 17/11/29
130	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC8		FK 17-12-3
140	HandFinish	4 pcs	11/23/17	11/23/17	0.00	0.39	HandFinish1		2017-12-07 JSL
150	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC7		BEB 17/12/08
151	Powdercoat	4 pcs	11/24/17	11/24/17	0.00	0.17	Powdercoat1		BR 17-12-13
155	QC	4 pcs	11/24/17	11/24/17	0.00	0.00	QC3		38
170	Packaging	4 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		2-88
180	QC21-SA	4 Ea	11/24/17	11/24/17	0.00	0.00	QC21		17-12-15

Part Op 100 - Cut blank:3.375" long

Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893

151 - MASK AS PER NOTE 9

M 138467. START: 1:10 O.V.T: 320 F INLSIT: 1:40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.000X05.000	1	10	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, LH	72.000Degrees ± 0.500	72.500 71.500	Angle	
2	Hardpoint Adaptr, LH	1.500Inches ± 0.030	1.530 1.470		
3	Hardpoint Adaptr, LH	0.030Inches ± 0.030	0.060 0.000		
4	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle	
5	Hardpoint Adaptr, LH	2.450Inches ± 0.030	2.480 2.420		
6	Hardpoint Adaptr, LH	1.300Inches ± 0.030	1.330 1.270		

DART
AEROSPACE
S015000

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Hawkesbury, ON K6
CANADA
TEL.: 1 613 632-5000
Email: sales@dartaero.com
www.dartaerospace.com



Hard Point Adapter, LH

PART NO: D4893-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/29/17

Job No: 167967

7	Hardpoint Adaptr, LH	0.750Inches ± 0.030	0.780 0.720
8	Hardpoint Adaptr, LH	2.500Inches ± 0.030	2.530 2.470
9	Hardpoint Adaptr, LH	1.250Inches ± 0.030	1.280 1.220
10	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220
11	Hardpoint Adaptr, LH	0.500Inches ± 0.030	0.530 0.470
12	Hardpoint Adaptr, LH	0.129Inches + 0.005 - 0.001	0.134 0.128
13	Hardpoint Adaptr, LH	0.204Inches + 0.005 - 0.001	0.209 0.203
14	Hardpoint Adaptr, LH	1.500Inches ± 0.030	1.530 1.470
15	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970
16	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970
17	Hardpoint Adaptr, LH	0.130Inches ± 0.030	0.160 0.100
18	Hardpoint Adaptr, LH	0.830Inches ± 0.030	0.860 0.800
19	Hardpoint Adaptr, LH	0.100Inches ± 0.030	0.130 0.070
20	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500
21	Hardpoint Adaptr, LH	1.750Inches ± 0.030	1.780 1.720
22	Hardpoint Adaptr, LH	1.460Inches ± 0.030	1.490 1.430
23	Hardpoint Adaptr, LH	1.650Inches ± 0.030	1.680 1.620
24	Hardpoint Adaptr, LH	4.000Inches ± 0.030	4.030 3.970
25	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220
26	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500
27	Hardpoint Adaptr, LH	0.750Inches ± 0.010	0.760 0.740
28	Hardpoint Adaptr, LH	1.015Inches ± 0.010	1.025 1.005

Plex 11/8/17 4:12 PM dart.poulin.mario

DQA: _____ Date: _____

QA Closed: DAK Date: FEB - 9 2018

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>167967</u> Part No. <u>D4893-1</u> NCR No. <u>18-6755</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
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